

Work Order ID 58059

April 22, 2010 1:04:58 PM



Page 1

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 22/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *10-4-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3838

Rev A

100



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1- cut D3838-1 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

SAD 10-05-05

4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: *111679*

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: *111679*

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

② Cpl 10-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 58059

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Page 2

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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

② PD 10.05.07

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/05/07

②

-041

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD

10-05-07

②

W/O:		WORK ORDER CHANGES					
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Page 3

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Stop



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Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/07
MF
10-5-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 22, 2010 1:05:03 PM

Page 1

Work Order ID: 58059



Parent Item: D3838-041



Parent Item Name: Rib Assembly (Basket Lid, LH)


Start Date: 22/04/2010

Required Date: 29/04/2010


Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1  Bushing		Manufactured	No				Each	21.0000	2.0000			

410-05-06

358159 

M304TS0.750W.065

Purchased

No



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
WA		21	
54072		9	
57595		12	

100 f 8.6105 2.1720



SAD 10-05-05

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
WA		8.610463158	
111148		2.7967	
113956		2.863	
114137		2.95076316	

1114482

2.1720

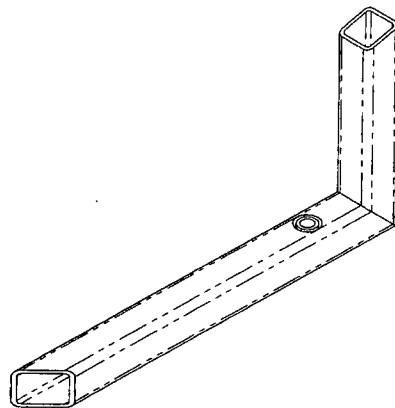
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

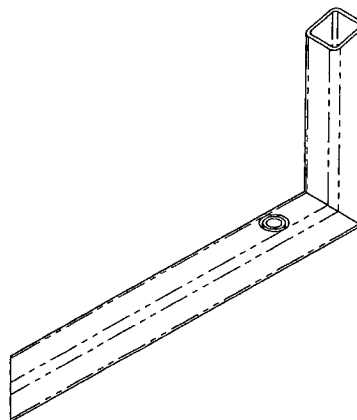
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NOTE: Date & initial all entries



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 58059
2810-4-22

RELEASED
08/10/08

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

A	NEW / ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3838** REV. A

SHEET 1 OF 3

TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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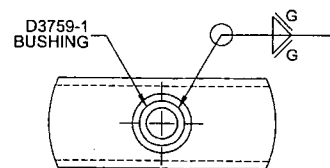
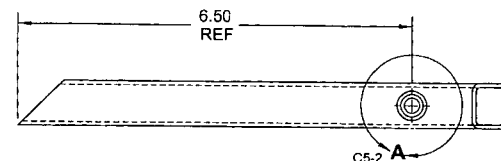
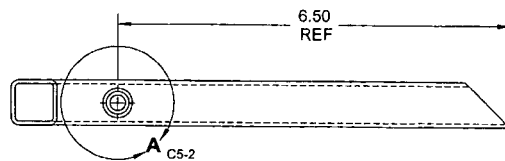
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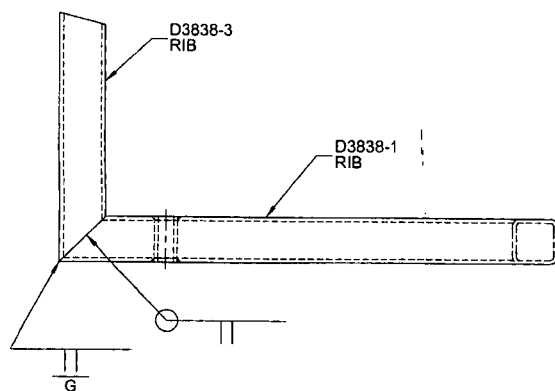
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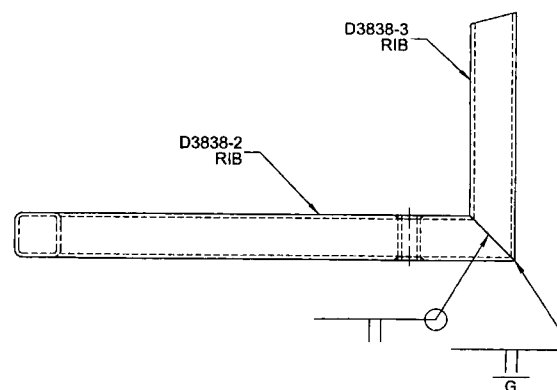
NOTE: Date & initial all entries



DETAIL A
D2-2
D7-2 SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, LH)

u10 58059

RELEASED
08/10/08

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

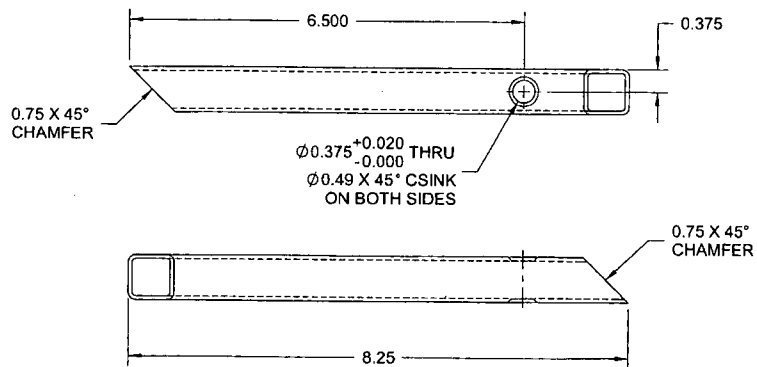
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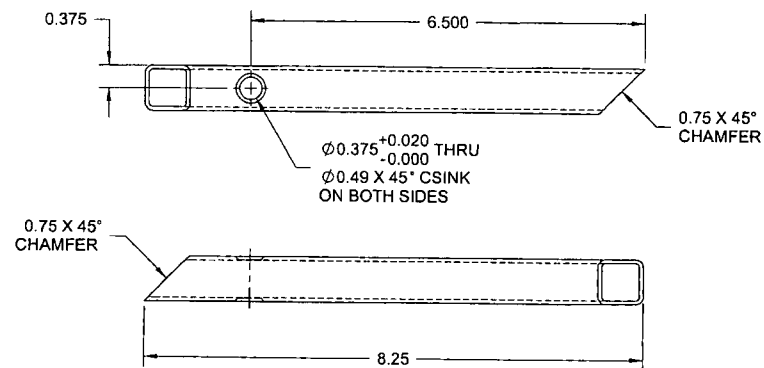
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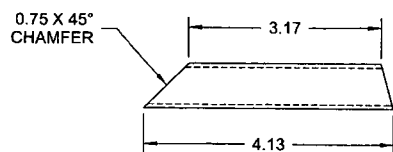
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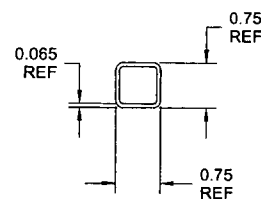
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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u/o 58059
RELEASED
24/11/2011

8 7 6 5 4 3 2 1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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